

7

Date: Wednesday, 1/30/2008 7:54:22 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: EXTRUSION 'I' BEAM TUBE 4"
Job Number	: 37065		
Estimate Number	: 10524		
P.O. Number	:	Part Number	: D25001100
This Issue	: 1/30/2008 S.O. No. :	Drawing Number	: D2500 REV G
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : PURCHASED PARTS	Drawing Revision	: G
Previous Run	: 24593	Material	:
Written By	:	Due Date	: 2/15/2008 Qty: 100 Um: Each
Checked & Approved By	: <u>[Signature]</u> 08/01/30		
Comment	: Est: A 05.11.14 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 5580

C208/01/31

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 100" long
- g) Bon L Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

(100)

★ SEE NCR

2.0	D25001100P	Skidtube Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)
EXTRUSION 'I' BEAM TUBE 4"

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500
Check Pull test per Dwg D2500 for compliance page attached.
Check hardness with Webster tester

[Signature]

(103)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2500-1-100 PAR #: N/A Fault Category: Supplier Bon-L NCR: Yes No DQA: 1 Date: 08/04/14
 QA: N/C Closed: 1 Date: 08/04/14

NCR: 37065		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.04.01	3	MAT'L CERT ONLY REFERENCES ASTM B221	CP 08.04.01 per QSI042	ENG REVIEWED ASTM & QQ SPEC AND ASTM B221-06 IS ACCEPTABLE. MAT'L OK	N/A	08.04.02	CP 08.04.01 per QSI042	08.04.02

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION "I" BEAM TUBE 4"

Job Number: 37065

Part Number: D25001100

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Back Haul

40 - ~~EL~~ SKID TUBE EL 8-4-2

63 -

BB 08/04/03.

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/08

Job Completion



u 08-08-04

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2500	REV. G SHEET 1 OF 3
DATE 07.04.17		TITLE EXTRUSION	SCALE NTS
A	96.03.19	NEW ISSUE	
B	96.03.24	CHANGE INTERNAL WEB	
C	96.04.26	ADD D2500-3 WEB	
D	96.10.07	ADD MATERIAL PROPERTIES	
E	96.10.24	CHANGE MATERIAL TEMPER	
F	97.09.29	CHANGE MAT. TO 6061-T6	
G	07.04.17	ADD NOTES 3,5,6	

RELEASED
07.06.28 *[Signature]*

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
MINIMUM ELONGATION = 8%

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO
ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY
TO ENSURE THAT THE BATCH MEETS THE ABOVE
MINIMUM MECHANICAL PROPERTIES

2. BREAK ALL SHARP CORNERS 0.010 MAX
3. ALL DIMENSIONS ARE IN INCHES
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. FOR D2500-1 PART NUMBER IS D2500-1-XXX WHERE XXX IS
CUT LENGTH (EX. D2500-1-190 IS 190" LONG)
D2500-1 EXTRUSION MANUFACTURED FROM:
A) BON L DIE # 897015 -> PREFERRED
B) CARADON MIDEAST DIE # PAH-28030
C) CARADON MTL DIE # MH-18868

6. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS
CUT LENGTH IN INCHES (EX. D2500-3-100 IS 100" LONG)
D2500-3 EXTRUSION MANUFACTURED FROM:
A) CARADON INDALEX DIE # MS-18867

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NO. 37065

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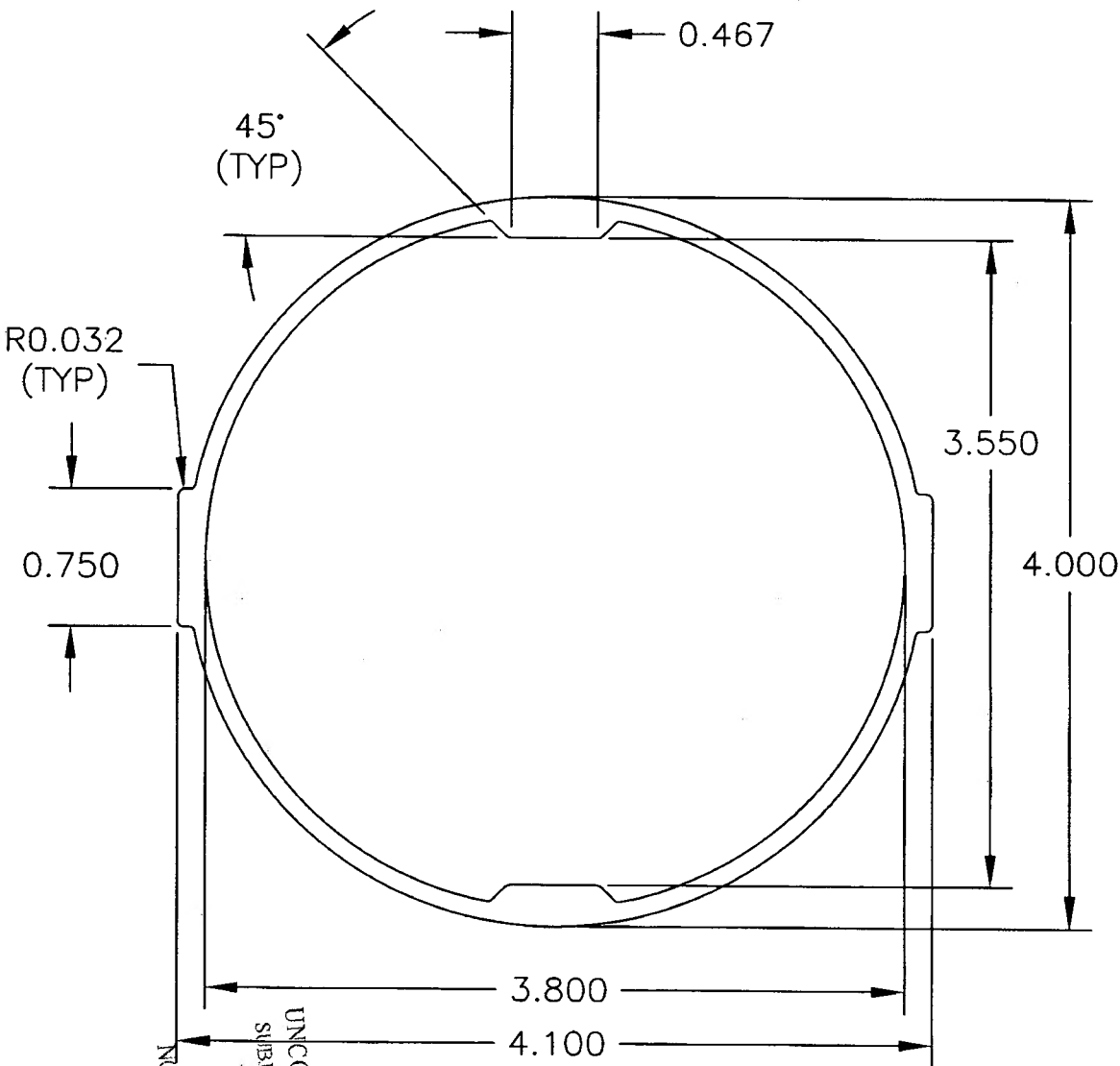
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DART

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2500
DATE	07.04.17			REV. G SHEET 2 OF 3
				TITLE EXTRUSION
				SCALE 1:1

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07.06.28 *[Signature]*



D2500-1

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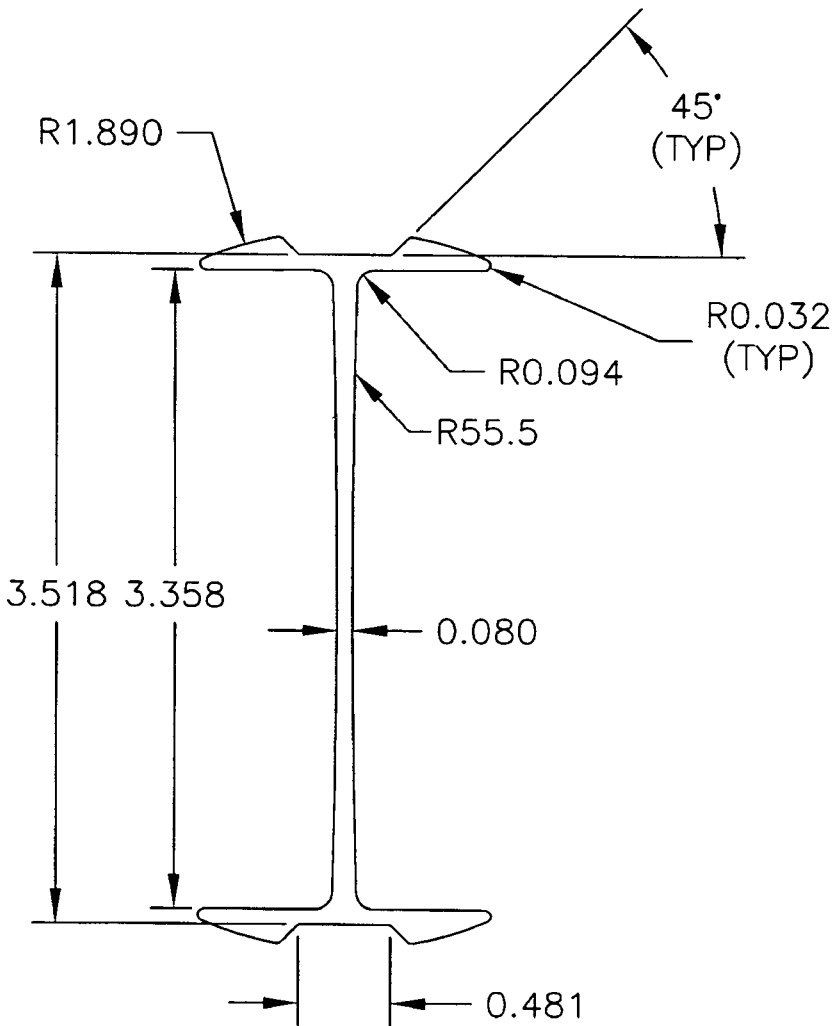
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CHECKED	APPROVED	DRAWING NO.	REV. G
<i>[Signature]</i>	<i>[Signature]</i>	D2500	SHEET 3 OF 3
DATE		TITLE	SCALE
07.04.17		EXTRUSION	1:1

RELEASED
07.06.28

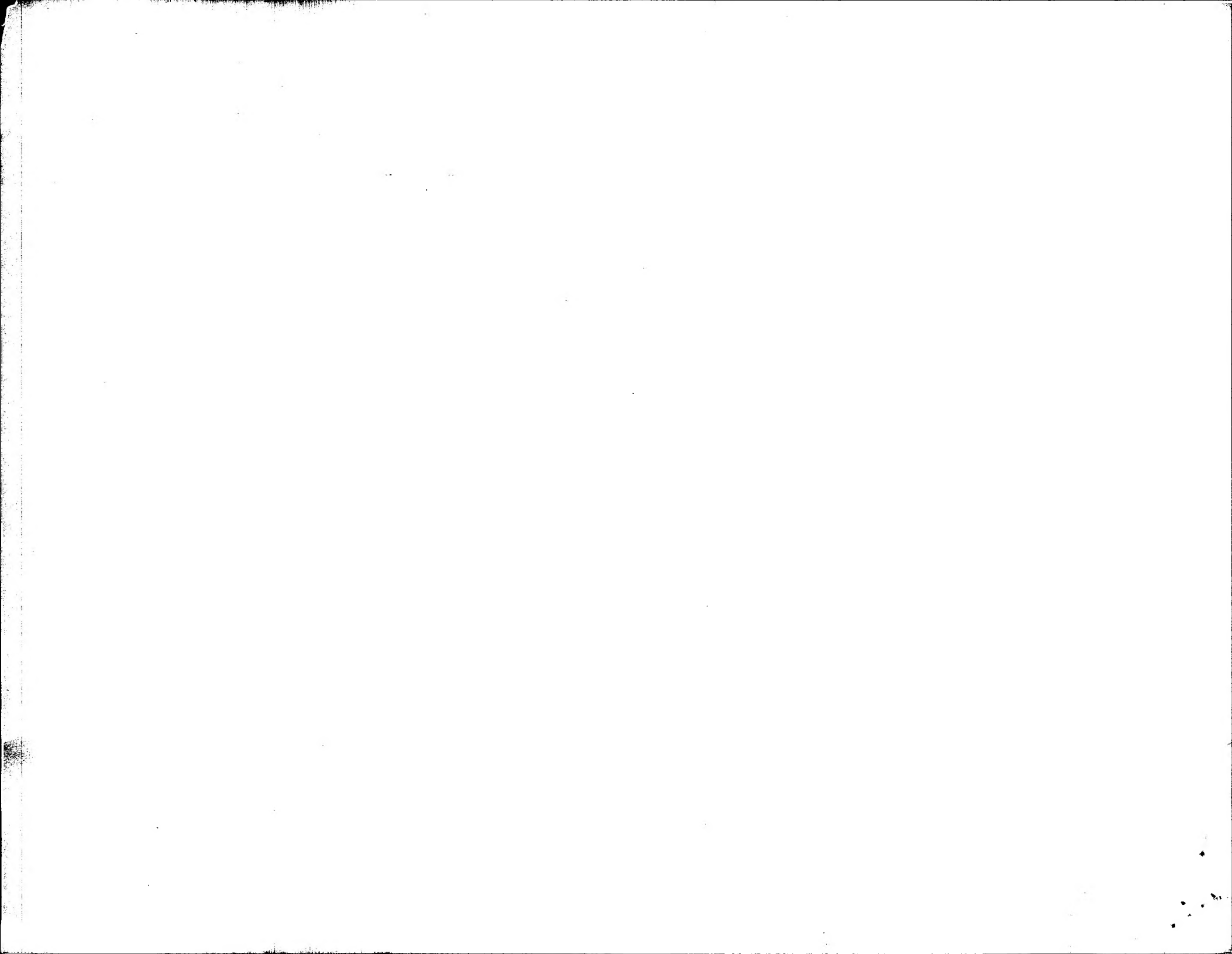


D2500-3

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INVOICING COMPANY AND LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

SHIPPING MANIFEST

ACCT# 00046024

MANIFEST DATE 03-03-08
MANIFEST NUMBER 636360
SALES ORDER NUMBER 22912

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE

TERMS / FREIGHT
O / P

SHIP TO DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200	SOLD TO / PURCHASER DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY ON K6A 1K7 CN PHONE 613-632-5200
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CREDIT REP HAMBROOK, PAU 905-508-3250	SALES REP
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LOCATION PIC	TRAILER NUMBER T1T	SALESMAN 59358	FIELD SALES REP Kutter A 450-435-6551	CUST SERVICE REP Burton D 905-427-2227
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CUSTOMER ID 46024	ORDER DATE 01/31/08	CUSTOMER PO NUMBER 5580	JOB	BILL OF LADING NUMBER 00374632
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ITEM NO.	ORIGINAL ORDER QUANTITY	UNIT	PREVIOUS SHIPPED QUANTITY	MFG. PART NUMBER	ALLOY & TEMPER	FINISH DESCRIPTION	THIS SHIPMENT			UNIT	QUANTITY DUE
				CUSTOMER PART NUMBER	LENGTH	FABRICATION DESCRIPTION	NBR OF PKGS	GROSS POUNDS	NET QUANTITY		
					CUTTING TOLERANCE	SHIPPING TOLERANCE					
01	100	KG	0	DAA-897105-3	6061 /T6	MILL	5	711	686	KG	0
		M	0	D2500-1-100	100"	CERTIFICATE OF COMP			261.62	M	0
		PC	0		+3/16 "	(+015-015,0115-0085)			103	PC	0
					-0 "						
					</						

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping manifests and signed and dated below by customers authorized representatives.
No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping manifest were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on the reverse side.

5	711	686	KG
		261.62	M
		103	PC
TOTALS			

103

CERTIFICATE OF COMPLIANCE

SIGNATURE ALUMINUM CANADA

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

(B&L)

Cert Date	Cert No	Sales Order	Page
03/03/08	174220	22912	1
Cust PO	B/L No	Lot	Date
5580	00374632	22912010	3/03/08

Sold To	Ship To
46024	46024
DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897105-3	100" MILL 6061 T6	D2500-1-100

Gross Weight	711 KGS
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Net Qty	686 KG	103 PC	262 M	5 PKG
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Specification	Die Desc
ASTM B221-06	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	301.2 / 43.7	274.7 / 39.9	8.0	.0	95

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI
.65	.21	.26	.05	.88	.06	.10	.01

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgment form. No other warranties are applicable.

Conchita Ko, QA Manager Signature Aluminum Canada Inc

